

Date: Wednesday, 10/3/2007 8:39:16 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 34987		
Estimate Number	: 11123		
P.O. Number	: <i>NIA</i>	Part Number	: D2460
This Issue	: 10/3/2007	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D2460 REV D
First Issue	: <i>NIA</i>	Project Number	: N/A
Previous Run	: 33212	Drawing Revision	: D
		Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/25/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	4 Um: Each
Comment	: Est Rev: F Added Finish as per Rev D 05-11-30 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
-----	----------	----------------



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
.5	D2244	Step Extrusion	<i>328216</i>

*KE 01-10-17*

4

2.0	D23381	End Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2338-1	End cap	<i>331209</i>

*KE 01-10-17*

4

3.0	D23382	End Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2338-2	End cap	<i>331210</i>

*KE 01-10-17*

4

4.0	D2459	204 Step Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch No.
1	D2459	Lug	<i>333233</i>

*KE 01-10-17*

4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:39:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34987

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 per Dwg. D2460

2-Weld per Dwg. D2460

A/R Alum rod

Batch: M105058

3-Debur

(use DT8793 to locate D2459)

SE 07.10.17  
SE 07.10.17  
SE 07.10.17

4  
4  
4

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SE 07.10.17 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.10.17 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.10.17

(4)

9.0

POWDER COATING

POWDER COATING



M-10 5068



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-10 07/10/18

(4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per dwg D2460

Batch: ~~M105058~~ M105694

FL 07/10/18 (4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

U. 07/10/18 (4)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:39:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34987

Part Number: D2460

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PK

C207110/22 (4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)  
10/10/22

Job Completion



ll 07.10.22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

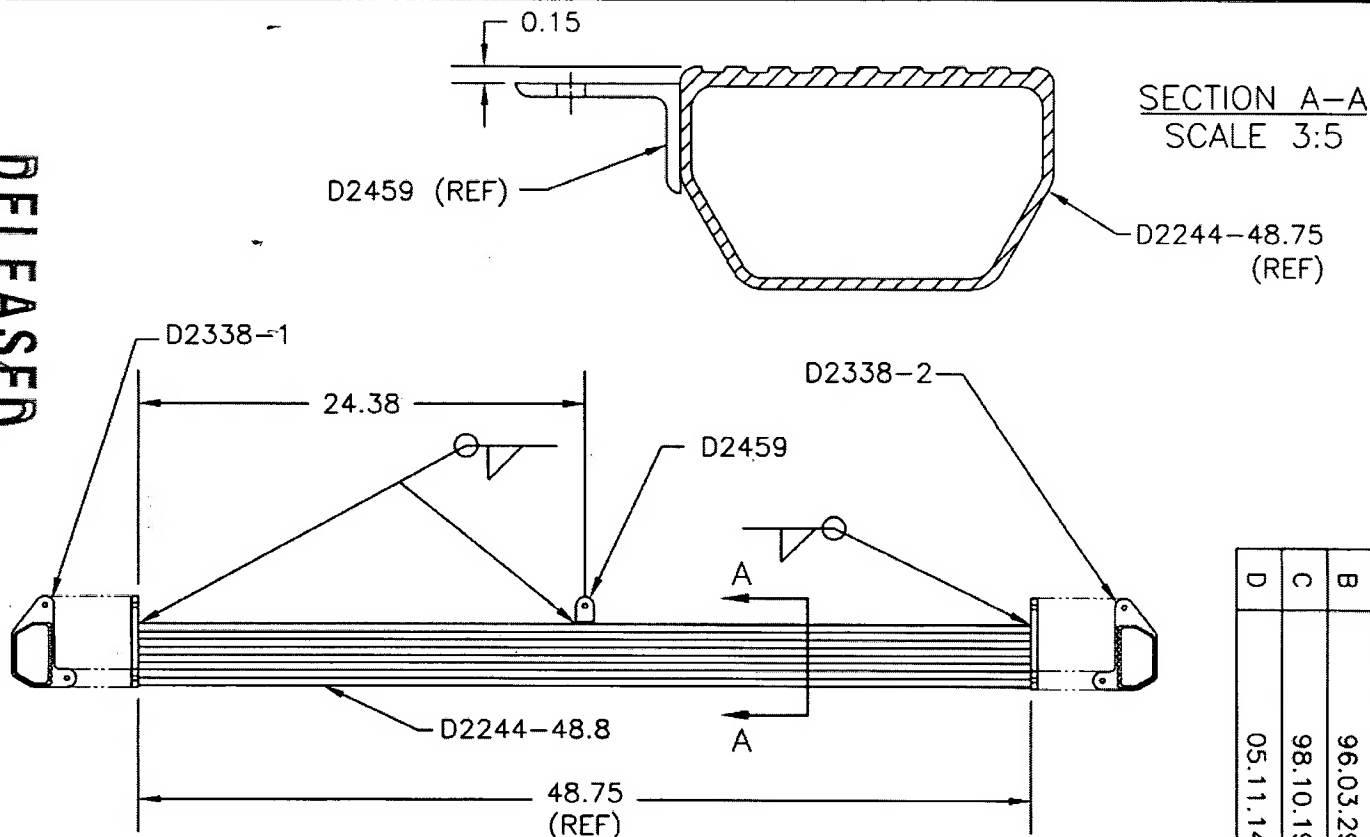
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		PH		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. 0
				D2460	SHEET 1 OF 1
DATE				TITLE	SCALE
05.11.14				STEP WELDMENT ASSEMBLY	1:10
A		95.01.25		NEW ISSUE	
B		96.03.29		CHANGE END PLATES	
C		98.10.19		ADDED SECTION A-A (TSR A915)	
D		05.11.14		UPDATE FINISHING NOTES	



#### D2460 STEP WELDMENT ASSEMBLY PARTS LIST

P/N	DESCRIPTION	QTY
D2460	STEP WELDMENT ASSEMBLY	X
D2244-48.8	EXTRUSION*	1
D2338-1	ENDPLATE	1
D2338-2	ENDPLATE	1
D2459	ANGLE	1

\*cut per drawing

#### D2460 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID TOP SURFACE TO BOTTOM OF  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34987

RELEASED  
05.11.28

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